Work Order ID 102526

Wednesday, May 29, 2013 9:58:39 AM

Page 1

Item ID:

D3137-5

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

**Start Date:** 

Item Name: Washer

Required Date: 5/30/2013

5/29/2013

**Start Qty: 20.00** Req'd Oty: 20.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals: **Process Plan:** 

Date: 13-5-26

Tooling:

Date:

Run Start

OC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours** 

Tool ID

Tool # Plan

Code

Qty

Accept Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

**Revision Nbr** 

D3137 100

Hardinge

Rev F

\*100\*

Hardinge CNC LATHE SMALL

0.00

Fix 13/05/30

Hardinge CNC Lathe Small

1-Machine as per Folio FA471 and Dwg D3137

2-Identify as D3137-5

3-Deburr

Memo

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

Quality Control

QC

Memo

0.00

F.K- 13/05/30

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

Quality Control

DQA: Date:					- Δ <b>P</b> T										
					WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE				_	AEROSPACE		
QA Closed:		Date:		-			<del>i</del>		W	ork Order up	odate only			_	
Work Orde	er:				DISPOSITION			AGAINS	T DI	PARTMENT	/PROCESS				
				_	Rework	1		Skid-tube Crosstub	e [	7	Water Jet		ngineering		
Part N	No.				Scrap			Machining Small Fa	_	Pro	d. Eng. Coor.	┨╴	Quality		
				_	Use-as-is			noforming Finishir	_		re/Packaging		Other		
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-	Cracks				Broken/Damage/Defect	_	Hardwa			Part Incorred	-		nperature/Cure		
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	Cuffs			$\vdash$	Contamination	$\overline{}$	1	ions Incomplete/Unclear		Part Moved	L	Wr	ong Stock Pulled		
	Crushin			$\vdash$	Countersink	$\overline{}$	1	ned/off center	_	Positioned V		_			
	Heat Tr			-	Cut Too Short	_	Mislabe			Power Loss/	Surge	Oth	ier		
		on Strip in	Tube	_	Drawing		Misread	1						_	
	Marks/(				Drill Holes	$\vdash$	Off-set							_	
		Sequence			Finish	$\overline{}$	ł	Calibration						_	
	Wave/T	wist in Tub	oe e		Fit/Function		Out of 9	Sequence							

Packaging

Packaging

Memo

Sur la commande Sur la commande

DQA: Date:												***	ADT		
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / L		Mark C	rdor	pdate only	_	AEROSPACE
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						Rework	]		Skid-tube	Crosstube			Water Jet		Engineering
Part i	No.					Scrap			Machining	Small Fab	┥.	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	P		re/Packaging		Other
NCR I	No			·····		Suspected Unapproved	]		Large Fab	Composite			Supplier		
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	<b>—</b>	at Treat				Cut Too Short	$\vdash$	Mislabe		L	Pow	er Loss/	Surge	Ot	her
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	l lw:	ave/Twi	st in Tub	e	1 .	Fit/Function	1	Out of S	equence						

Work Order ID 102526 Wednesday, May 29, 2013 9:58:39 AM Item ID: D3137-5 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Washer **Start Date:** 5/29/2013 **Start Oty: 20.00** \*20\* **Cust Item ID:** Required Date: 5/30/2013 Req'd Qty: 20.00 **Customer:** Reference: Run Start **Approvals: Process Plan:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Reject Set Up/ Tool # Plan Accept Reject Work Center ID Description

QC21- Final Inspection - Work Order Release

Memo

170

OC.

\*170\*

Quality Control

**Run Hours** 

0.00

0.00

MW 13-05-30 MF

Insp.

Number Stamp

Qty

Code

Oty

Page 3

DQA: Date:					–										
					WORK ORDER NON	-CO	ONFO	RMANCE / L	JPDATE					AEROSPACE	
QA Closed:		Date	:					<del></del>		Wo	rk Order up	odate only			
Work Orde	er:				DISPOSITION				AGAINST	DEP	PARTMENT	/PROCESS			
					Rework	]		Skid-tube	Crosstube			Water Jet		Engineering	
Part N	۱o.				Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality	
					Use-as-is	1	Therr	moforming	Finishing		Rec/Sto	re/Packaging		Other	
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Landir	ng Gear				General		-					_			
	Bending	;			Bend		Folio/P	rogram		$\bigsqcup$	Outside Dim	ensions	Pr	essure/Forced	
	Centre I	Not Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	Se	et-up	
	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct [	Te	emperature/Cure	
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/L	Jnqualified		Part Lost/Mi	ssing	w	/eld	
	Cuffs				Contamination		Instruct	tions Incomplete,	/Unclear		Part Moved	į	]w	rong Stock Pulled	
	Crushin	g			Countersink		Misalig	gned/off center			Positioned <b>V</b>	Vrong _	_		
	Heat Tre				Cut Too Short		Mislabe	eled			Power Loss/	Surge	О	ther	
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	Marks/0	hatter			Drill Holes		Off-set			_					
		Sequence			Finish		Out of (	Calibration		_					
j	Wave/T	wist in Tul	be		Fit/Function		Out of	Sequence							

## **Picklist Print**

Wednesday, May 29, 2013 9:58:36 AM

Work Order ID:

102526

Parent Item:

D3137-5

Parent Item Name:

Washer

Start Date: 5/29/2013

Required Date: 5/30/2013

**Start Qty: 20.00** 

Required Qty: 20.00

**Comments:** 

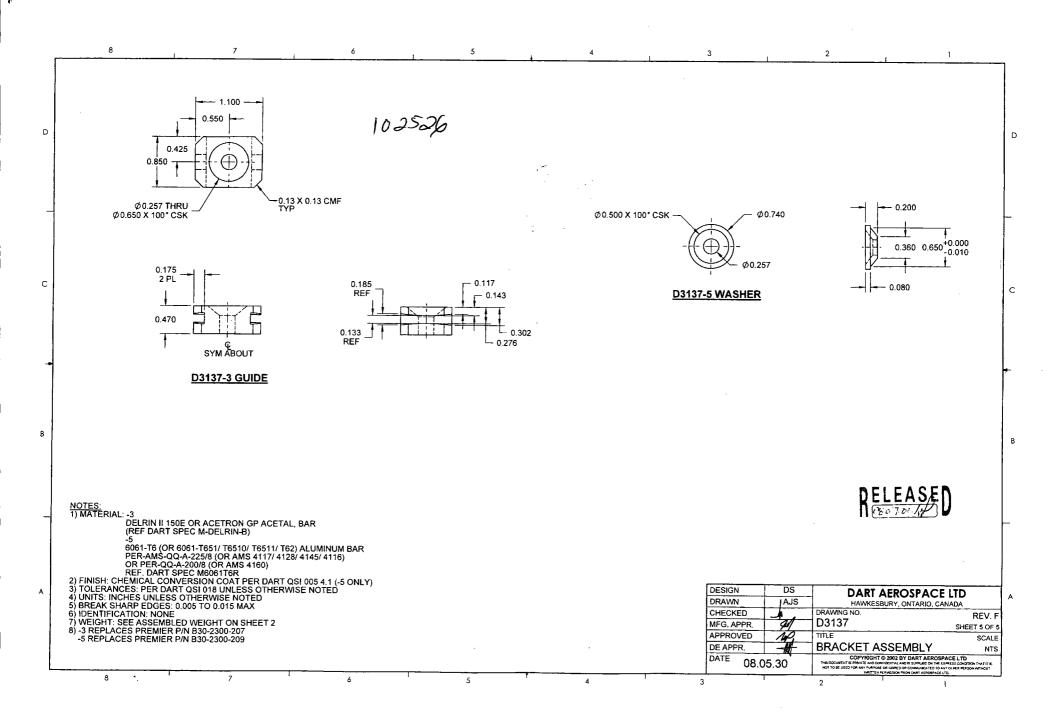
IPP A04.11.04New issueKJ/JLM

IPP Rev B 08.07.03 ECN1207 EC verified by DD Replacement

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"	· · ·	Purchased	No	*****		100	f	82.3340	0.0208	0.437894	17		
				<b>Location</b>		Loc Qtv	<u>Lo</u>	c Code					
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DQA:		_ Date:			–										
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Work Order	· ··				DISPOSITION			AGAINST	r DE	PARTMENT	/PROCESS				
WOIR Older	•			_	Rework	1		Skid-tube Crosstube	<u></u>	1	Water Jet	_	Engineering		
Part No	).				Scrap			Machining Small Fab		Pro	d. Eng. Coor.		Quality		
					Use-as-is		1	noforming Finishing		-1	re/Packaging	-	Other		
ŅCR No	o.				Suspected Unapproved			Large Fab Composite		1	Supplier	⊢			
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Root				Desci	ription of work order update	1	Initial	Action		Sign &					
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Operator															
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				- <b></b>		FAI	ULT CAT	regory							
Landing	_				General		l- :: /s		_	1			1		
	Bending	- <b>.</b>		-	Bend BOM/Bauta		1	rogram	-	Outside Dim			Pressure/Forced		
-	Centre No	ot Concer	itric		BOM/Route	-	Grain		$\vdash$	Over/Under		-	Set-up		
-	Crimp/Kir	مامعنا المام	Maria	$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa		$\vdash$	Part Incorred		_	Temperature/Cure		
-	Cuffs	ik/kibbie	/ wave	$\vdash$	Burrs Contamination	$\vdash$	1	on Incomplete/Unqualified	$\vdash$	Part Lost/Mi	ssing		Weld		
-	Crushing			$\vdash$	Countersink	_	1	ions Incomplete/Unclear	-	Part Moved Positioned V			Wrong Stock Pulled		
-	Heat Trea	o†		$\vdash$	Cut Too Short	$\vdash$	Mislabe	ned/off center	-	Positioned v	•	_	Other		
<del>-</del>	Inspection		Tuhe	H	Drawing	Н	Misread			Trower ross/	onike	Ц.	Other		
-	Marks/Ch	٠.	Tube	H	Drill Holes	Н	Off-set	4							
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	Wave/Tw	•		-	Fit/Function	$\vdash$		Sequence							

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DQA:			Date:			·							
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						Rework	]		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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	Crac					Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct	Temperature/Cure
	_	-	/Ripple/	/Wave		Burrs		Inspect	ion Incomplete/Un	nqualified	Part Lost/Mi	ssing	Weld
	Cuffs					Contamination		ł	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
	Crus					Countersink	<u> </u>	1	ned/off center		Positioned V		_
		Treat				Cut Too Short	L	Mislabe			Power Loss/	Surge	Other
	_		Strip in	Tube	$\square$	Drawing	<u> </u>	Misread	d		· · · ·		
		ks/Chat			$\square$	Drill Holes	igsqcup	Off-set					
	_	-	quence		$\square$	Finish	_	1	Calibration				
	Wav	e/Twist	t in Tub	e		Fit/Function		Out of S	Sequence				

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DART AEROSPACE LTD	Work Order:	102526
Description: Washer	Part Number:	D3137-5
Inspection Dwg: D3137 Rev: F		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	,73%	7		FK-04	Ven.
Ø0.257	+0.005/-0.000	, २६४	1		h	c <sub>l</sub>
Ø0.500 x 100°	+/-0.010	345 × 100°	V		ì.	١
Ø0.360	+/-0.010	.340	7		A	•
0.080	+/-0.010	. 0%0	7		h	h
0.200	+/-0.010	. 199	V		1	٨.
Ø0.650	+0.000/-0.010	= 645°	\		h	h
			_			·
:						,

Measured by:	Audited by:	13	Prototype Approval:	NI/A
Date: 13/05/25	Date:	3-5-30	Prototype Approval:  Date:	N/A N/A
(3/03/50		7-4 70	Dutc.	14//3

Rev	Date	Change	Revised by	Approved
Α_	04.11.12	New Issue	KJ/JLM	
В	06.03.15	Ø0.650 dimension added; Ø0.660 dimension removed	KJ/JLM , ,	
С	08.12.02	Dwg Rev updated	KJ/DD ox	13/

DQA:			Date:					<b>®</b>							
QA Closed:			Date:			WORK ORDER NON	I-C(	JNFOI	RMANCE / U	IPDATE	Work	: Order up	odate only		AEROSPACE
Work Ord	or:					DISPOSITION				AGAINST	DEPA	RTMENT,	/PROCESS		
Part I	 No					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jei d. Eng. Coor re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		nitial	Action			Sign &			
Cause		Date	Step	Qty		or non-conformance	1	ief Eng				Date	Verification	on I	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved			02 2 2 1	100				, 0	7 <sub>4</sub> **	2	<i>y</i> -				
							FAI	JLT CAT	EGORY						
Landi	ng Gea	r				General	FAL	JLT CAT	EGORY				<u>.                                    </u>		n//
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instructi	on Incomplete/U ons Incomplete/U ned/off center led	· ·	Ov Pa Pa Pa Po	utside Dime ver/Under rt Incorrect rt Lost/Mis rt Moved esitioned W wer Loss/S	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
·	$\vdash$				-	Finish	-		alibration						
	Turning Sequence Wave/Twist in Tube				<u> </u>	Fit/Function	H		equence						

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